

Work Order ID 70542

Friday, June 10, 2011 2:57:32 PM



Page 1

Item ID: D2842-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, 206 Float

Start Date: 6/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2842	Rev B

100 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
2-Drill D2842-1 using Jig DT8271 as per Dwg D2842
3-Deburr and bevel ends for welding

AE 11.06.14.

(12)

0

110 0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

CPL 11.06.15

120 0.00



Weld per dwg A/R Aluminum rod Batch: *114103*
Large Fab *115928*
117884

Memo

0.00

Large Fab

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per
Dwg D2842

AE 11.06.16 2 φ

Large Fab

2-Grind end cap weld flush

AE 11.06.16
AE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

2 0 BE 11/06/17

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S w 106/17



150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11.26.15

W/O:		WORK ORDER CHANGES					
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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



SB 11/06/20

②

QC

Memo

0.00

Quality Control

170

Weld per dwg A/R Aluminum rod Batch: 114703 0.00



Large Fab

0.00

Large Fab

Memo

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

2-Grind end cap weld flush.

11.06.20

2

φ

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/10/21

77

64

W/O:		WORK ORDER CHANGES					
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Required Date:	6/15/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

191	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***								

200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 11:40
 OVEN TEMPERATURE: 320°F
 FINISH TIME: 12:10

M116964

2X
 LH

2X
 LH
 M-11/06/22

2X
 LH
 M-11/06/22

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 ϕ BR 11-6-23

220

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: 116869

② BR 11-6-23

230

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S ulo6/23



W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PRR 70539

0.00

Packaging

11/6/27 (2)

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/27

MF
11-06-27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Friday, June 10, 2011 2:57:39 PM

Parent Item Name: Step Assembly, 206 Float

Required Date: 6/15/2011

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10L	NAS1149C0332R	Purchased	No			100	Each	0.0000	3	6			
washer													
D2622-120C		Manufactured	No			120	Each	35.7000	1	2			
Step Extrusion													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				HALL		6							
				64409		6							
				WA		29.7							
				46910		2							
				<u>66970</u>		27.7							
D2734		Manufactured	No			120	Each	48.0000	2	4			
Step End Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		45							
				<u>69537</u>		45							
				WA015		3							
				66143		3							
D3459-3		Manufactured	No			120	Each	29.0000	2	4			
Float Step Mounting Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		29							
				<u>62956</u>		29							

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, June 10, 2011 2:57:39 PM

Work Order ID: 70542

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

D3459-1 Manufactured No

220 Each

23.0000

2

4



Float Step Mounting Plate



11-06-16

Location

Loc Qty

Loc Code

WA017

23

62955

23

MS27039C1-07

Purchased

No

220

Each

65.0000

3

6



screw



4

Location

Loc Qty

Loc Code

ST293

65

117423 ✓

65

NAS1329C3KB130

Purchased

No

220

Each

64.0000

3

6



insert



6 BK 11-6-23.

Location

Loc Qty

Loc Code

FP-A

14

115719 ✓

14

ST276

50

117679

50

NAS1515H3L

Purchased

No

220

Each

268.0000

3

6



WASHER



6 BK 11-6-23.

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

228

113362 ✓

228

6 BK 11-6-23.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

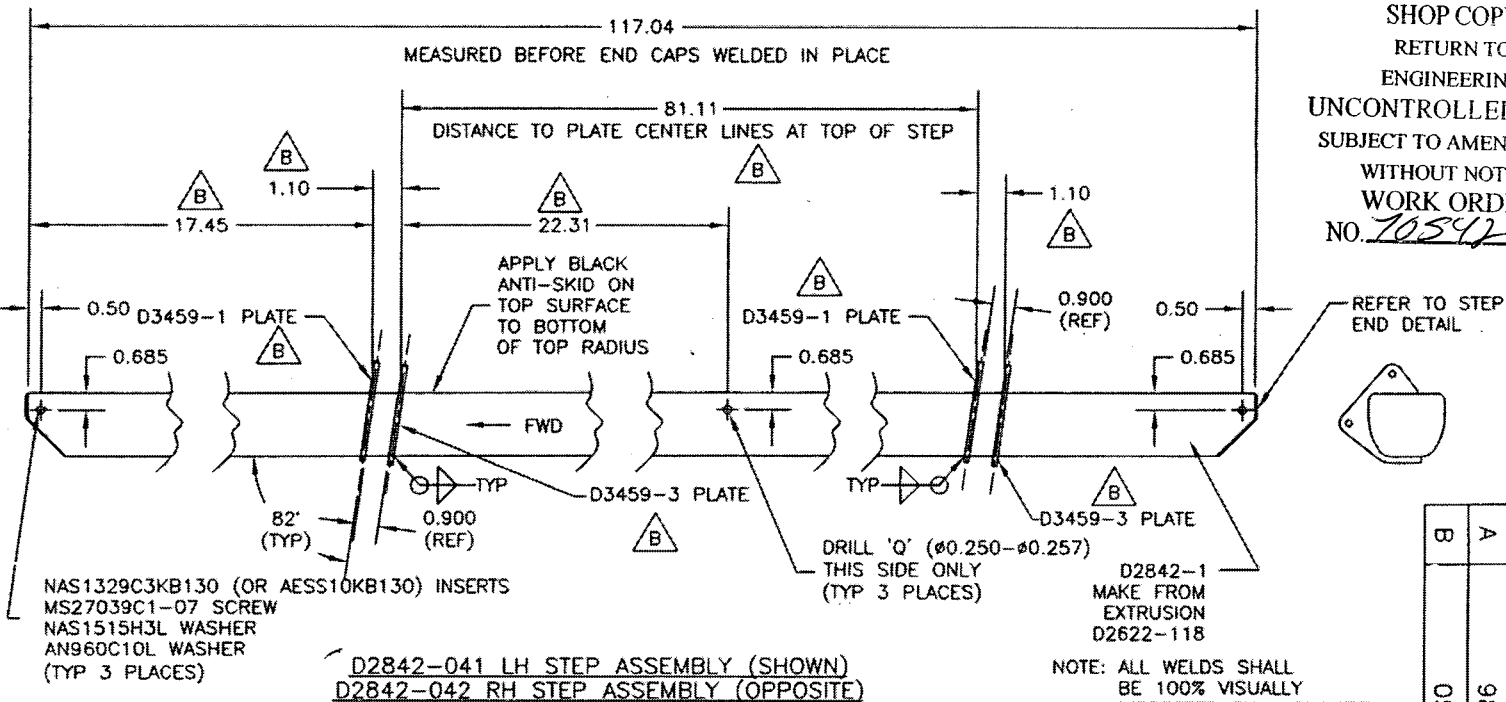
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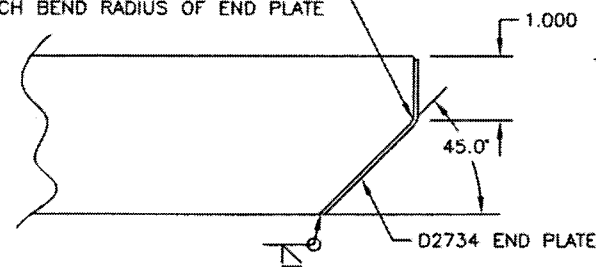
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D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70542

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2842
DATE 05.09.23	05.09.23	206L/407 FLOAT STEP ASSEMBLY
		RE-DESIGN, ADD D3459-1/-3
		NEW ISSUE
		SCALE NTS
		SHEET 1 OF 1
		REV. B

RELEASED
05-11-14

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